

ASAP

Work Order ID 54210

December 03, 2009 9:14:56 AM



Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Fwd

Start Date: 12/3/2009 Start Qty: 1.00

Required Date: 12/22/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *09/12/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-664-141	Rev D

100	DOCUMENT CONTROL	0.00
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DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-664-101. CHG003

2009

110	Pick Kit	0.00
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Packaging

Packaging

Memo

0.00

Packaging

120	BENDING MACHINE - CROSSTUBES	0.00
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CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

CNC Alpha 160 Bender



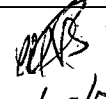

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

PK → *MB 09-12-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/09	100	take 5 over Bent R.L. wiring program was saved in bench. operator error while saving	 09/12/08 051042	- Take 5 scrap no replace	 09-12-09		 09/12/08 051042	 09/12/09

TE: Date & initial all entries

Work Order ID 54210



Page 7

Work Order ID 54210



Page 5

December 03, 2009 9:14:56 AM

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Page 2

December 03, 2009 9:14:56 AM

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Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID,

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00

QC

Memo

0.00

Quality Control

140

Crosstubes

0.00

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburf & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

Dart Aerospace Ltd

W/O:

WORK ORDER CHANGES

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W/O:

WORK ORDER CHANGES

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NOTE: Date & initial all entries

Picklist Print

December 03, 2009 9:16:52 AM

Page 1

Work Order ID: 54210

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-664-101TRNRevC		Manufactured	No			110	Each	2.0000	1.0000			



Crosstube Turning Detail



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	2	
53256	1	
53257	1	

D3595-063-450RevA Manufactured No



RUBBER CUSHION

230 Each 196.9689 42105



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	92	
52447	92	
Main Warehouse		
ST	104.9689	
38959	2	
43210	2.59	
46465	0.3789	
53775	100	

MB 09-12-04

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased	No			220	Each	201.0000	4.0000			



Clamp(per MIL-DTL-8783C)



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	201	
107456	2	
108111	3	
108975	17	
109181	42	
109644	10	
111282	4	
111429	1	
112495	22	
112919	25	
113281	25	
113282	50	

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2893-1RevB

Manufactured

No

220

Each

72.0000

2.0000



2.75 Support

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

25657

6

47109

2

47637

16

51775

19

53125

19

53340

10

D3428-1RevA

Manufactured

No

240

Each

11.0000

1.0000



Placard

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST096

11

50790

11

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Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009



Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6-35A 		Purchased	No			240	Each	58.0000	4.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	58	
112314	38	
112805	20	

AN6-36A 		Purchased	No			240	Each	123.0000	4.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	123	
109632	1	
110382	2	
112314	70	
113121	50	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 54210

Parent Item: D212-664-101RevC

Parent Item Name: Crosstube Fwd



Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Date: 12/3/2009

Required Date: 12/22/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6 		Purchased	No			240	Each	524.0000	6.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	524	
105077	22	
110002	5	
111548	8	
111578	400	
112492	89	

AN960JD616



Washer

Purchased

No

240

Each

847.0000

18.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	847	
112314	47	
112828	500	
113149	300	

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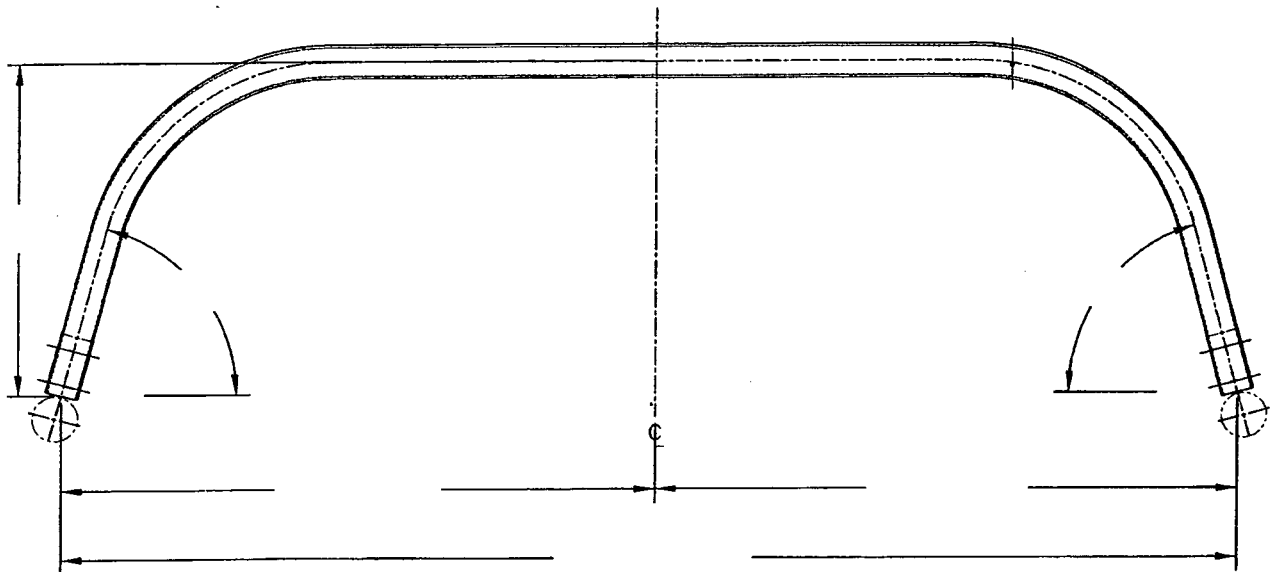
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DART AEROSPACE LTD		Work Order:	84210
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

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Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS
6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34210
R/0912-3

RELEASED
2009-10-29
M

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-141	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

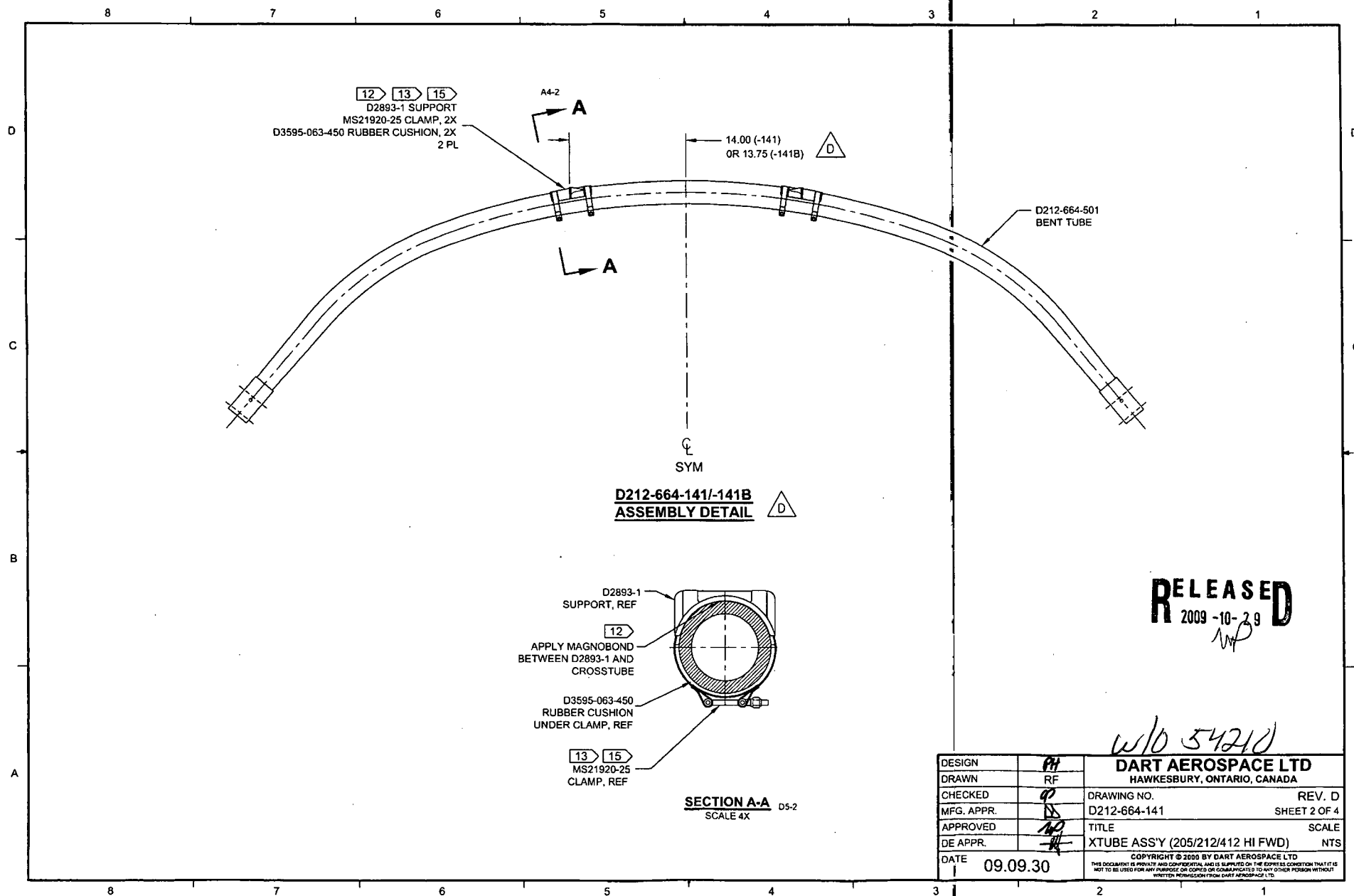
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RELEASED
2009-10-29

W10 54210

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 2 OF 4
APPROVED	147	TITLE	SCALE
DE APPR.	14	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

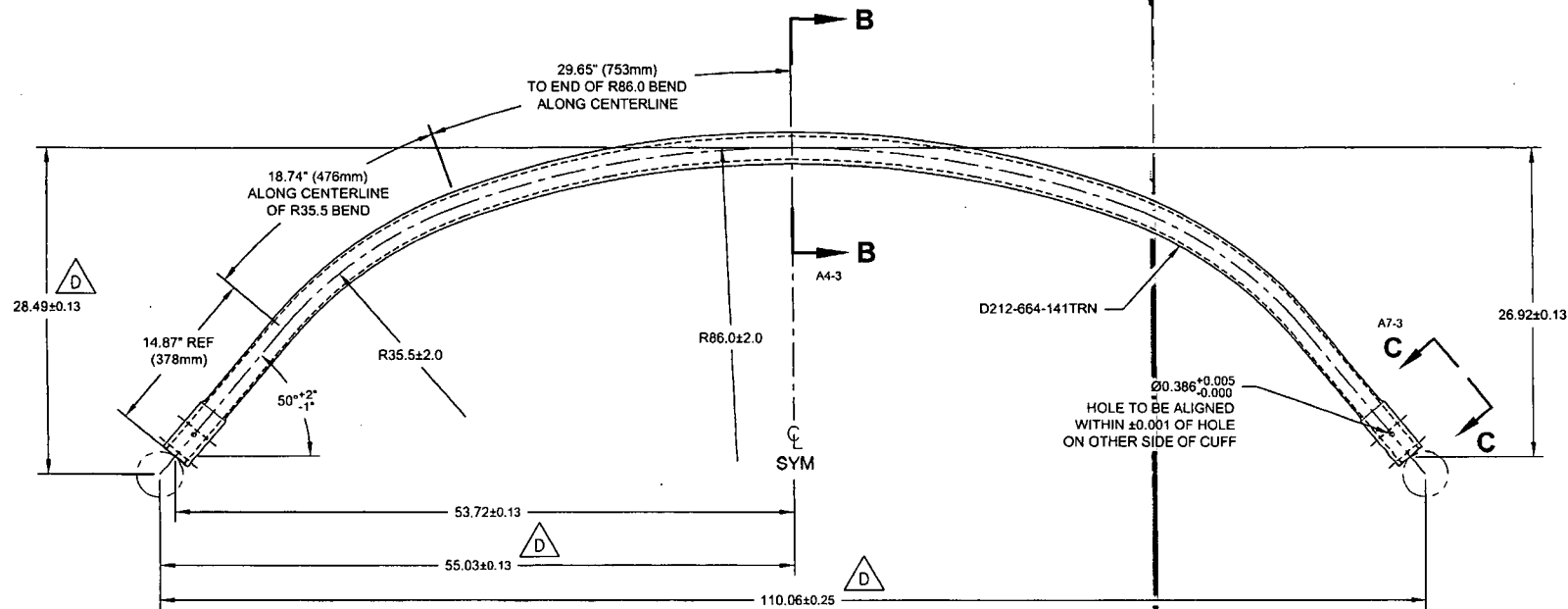
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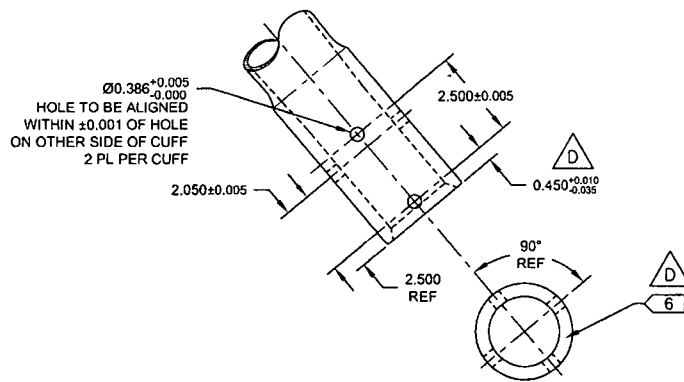
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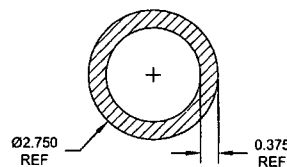
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D212-664-501
BENDING AND DRILLING DETAIL



VIEW C-C: CUFF DETAIL C2-3
 SCALE 3X



SECTION B-B C4-3
 SCALE 4X

RELEASED
 2009-10-29

wlo 34210

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D212-664-141	SHEET 3 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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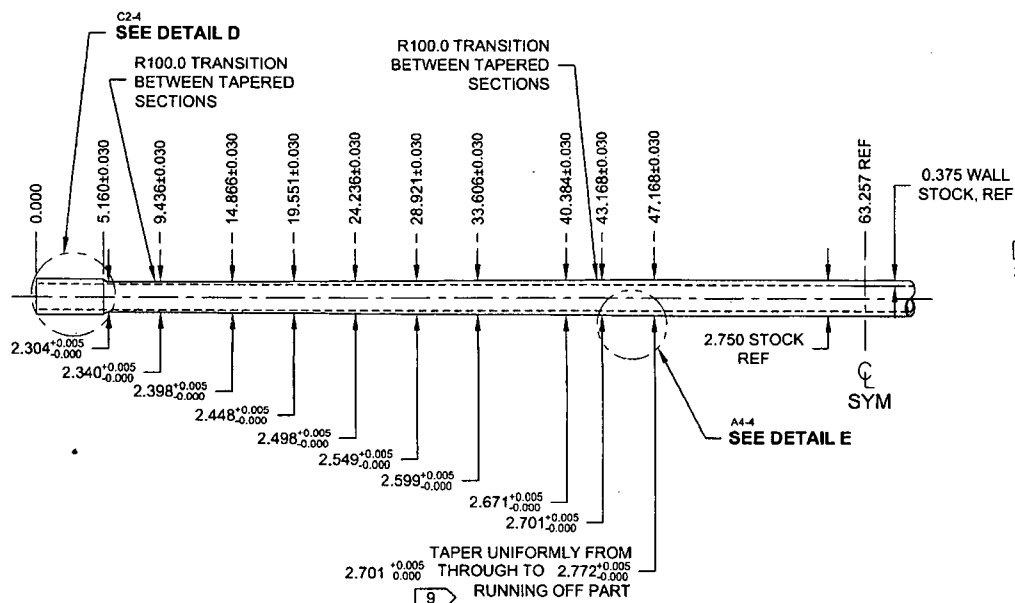
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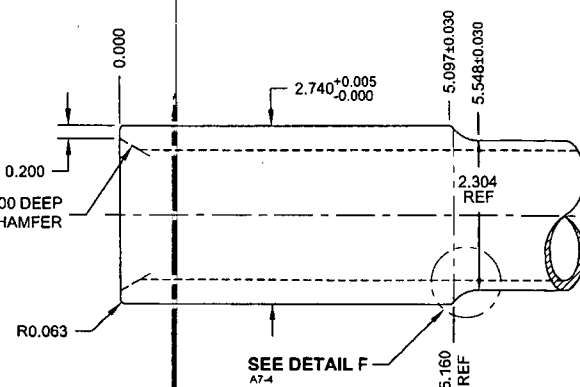
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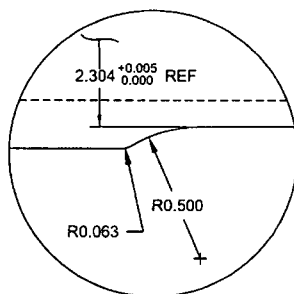
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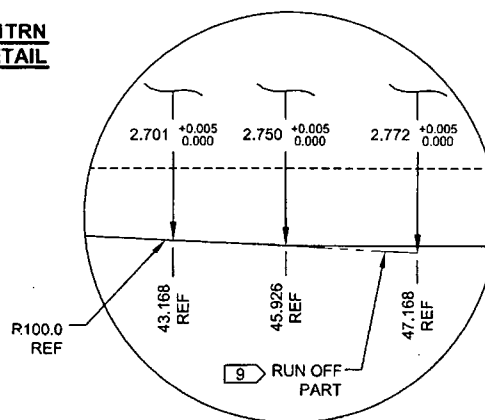
9
30° X 0.500 DEEP CHAMFER



DETAIL D:
CROSSTUBE CUFF D8-4
SCALE 5X



DETAIL F:
CUFF TRANSITION C2-4
SCALE 10X



DETAIL E:
TAPER RUN-OFF C5-4
NOT TO SCALE

RELEASED
2009-10-29

W1054210

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. D
MFG. APPR.	RS	D212-664-141	SHEET 4 OF 4
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries